

Date: Tuesday, 15/04/2008 7:30:10 AM
 User: Linda Lacelle

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: LID PRO ARM ASSEMBLY (SHORT)	
Job Number	: 38597		Part Number	: D2332041	
Estimate Number	: 10258		Drawing Number	: D2332	
P.O. Number	:		Project Number	: N/A	
This Issue	: 15/04/2008 S.O. No. :		Drawing Revision	: C	
Prsh Rev.	: NC		Material	:	
First Issue	: / / Type : SMALL /MED FAB		Due Date	: 22/04/2008 Qty: 28	
Previous Run	: 37387			Um: Each	
Written By	:				
Checked & Approved By	:				
Comment	: Est: B 02.08.12 Re-format; Incorporated D2332-13/-11/-7/-5 KJ/ RF				

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	Barcode
1.0	M304TR1000WO49	304 RD Tube 1.0" x .049W	
		Comment: Qty.: 0.4331 f(s)/Unit Total: 10.3950 f(s) Material: 1.000" OD x 0.049" wall SS Tube (Seamless)	
		M105750 12 M107573 16x Batch	
2.0	M304R250	1/4" 304 SS Roundbar	
		Comment: Qty.: 0.1092 f(s)/Unit Total: 2.6208 f(s) 3-276 Material: Ø0.250" 304SS Rod	
		M105750 12 M107387 308/04/28 Batch	
3.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1	

Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Cut to length as per Dwg D2332 (D2332-7) Locking Collar

2-Cut to length as per Dwg D2332 (D2332-5) Stop Pin

3-Deburr

4.0 M304TR0500WO35 304 RD Tube .500 x .035W

Comment: Qty.: 1.2502 f(s)/Unit Total: 30.0048 f(s)

304 RD Tube .500 x .035W

M107166 18

M107593 12



308/04/28

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE			By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Job Number:		
Seq. #:	Machine Or Operation:	Description :
5.0	BRAKE NC	NC BRAKE
Comment: NC BRAKE		
Punch or form to length as per Dwg D2332 (D2332-11) using DT8012 (Note: Make (2) D2332-11 Prop Arms per assembly.)		<i>808/04/15 (48)</i>
6.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1
Comment: LARGE FABRICATION RESOURCE 1		
1-Drill hole in D2332-11 as per Dwg D2332 using Drill Jig DT8459. Deburr. (Drill 1 per assembly)		<i>808/04/28</i>
2-Weld D2332-11 and D2332-5 as per Dwg D2332 using Welding Jig DT8298. (Weld 1 per assembly)		<i>30x</i>
A/R	SS Rod Batch: M107051	<i>808/04/28 08-04-28 SP</i>
7.0	QC9	VISUAL WELDING INSPECTION
Comment: VISUAL WELDING INSPECTION		<i>P.D. 08-04-29</i>
8.0	QC5	INSPECT WORK TO CURRENT STEP
Comment: INSPECT WORK TO CURRENT STEP		<i>808/04/28</i>
9.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
Comment: SMALL & MEDIUM FAB RESOURCE 1		
1-Tumble		
2-Assemble as per Dwg D2332		<i>808/04/30 (28)</i>
10.0	AN44A	Bolt
Comment: Qty.: 1.0000 Each(s)/Unit Total : 24.0000 Each(s)		
Pick:		
Qty	Part Number	Description
1	AN4-4A	Bolt
Batch: M101291 (192)		<i>M106918 (192)</i>
		<i>808/04/30</i>

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D2332-041 PAR #: N/A Fault Category: Prod / FAB - Large NCR: Yes No DQA: SD Date: 02/05/01
 QA: N/C Closed: HP Date: 02/05/01

NCR: 38597		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
08/04/29	# 10	During inspection it was found that 2 arms have a foreign object inside them R.C. Arms went clean out enough after welding	J 08/04/29	- Ensure that all foreign objects are removed after drilling. Add a comment at the beginning of b.o.2 "Ensure to remove all foreign objects," prior to welding.	SD 08/04/29	C 08/04/29	J 08/04/29	J 08/04/29
				Scrap and Destroy Qty <u>(X2)</u> no replace.				

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Job Number:



Seq. #: Machine Or Operation:

Description :

11.0 AN960JD416L Washer



Comment: Qty.: 3.0000 Each(s)/Unit Total : 72.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
3	AN960JD416L	Washer	1107008

EBO8/04/30

12.0 MS21042L4 Nut



Comment: Qty.: 1.0000 Each(s)/Unit Total : 24.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
1	MS21042L4	Nut (or -4)	1106051

EBO8/04/30

13.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

5 08/04/30 428

14.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

R 8/4/30 (28)

15.0 QC21 FINAL INSPECTION/W/O RELEASE



08/05/01 JJ

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



U 08.05.01

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

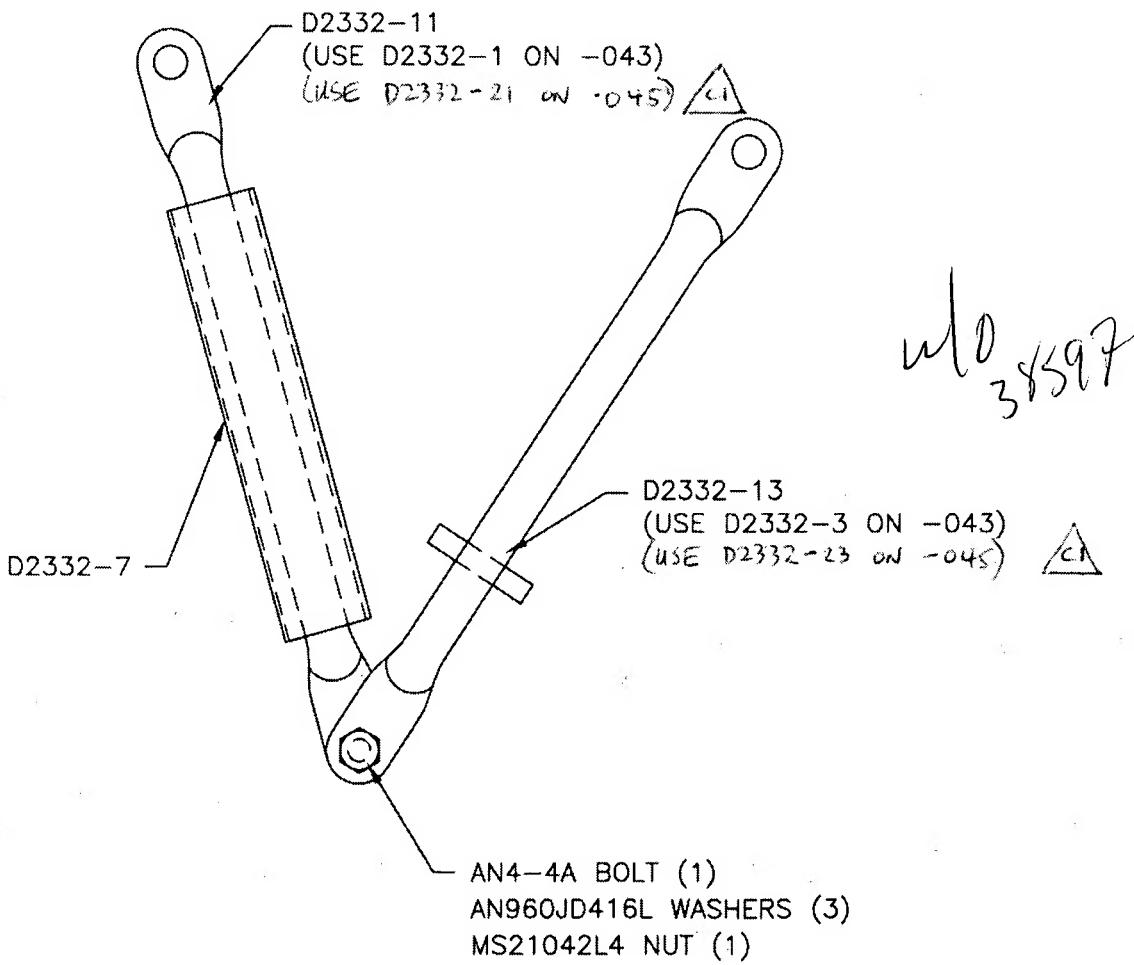
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO.	REV. C
		D2332	SHEET 1 OF 2
DATE		TITLE	SCALE
03.07.03		LOD PROP ASSEMBLY	NTS
A	94.12.16	NEW ISSUE	
B	97.09.30	CHANGE 416 WASHERS TO 416L	
C	03.07.03	MAKE -041 PROP 6.69" LONG (STD) MAKE -043 PROP 8.00" LONG (OPT.)	
C1	03.08.06	ADD -045 PROP (7.25" LONG)	



D2332-041 SHOWN
(D2332-043 SIMILAR)
(D2332-045 SIMILAR) CA

Dart Aerospace Ltd

W/I/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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DART

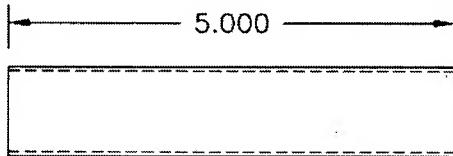


1994

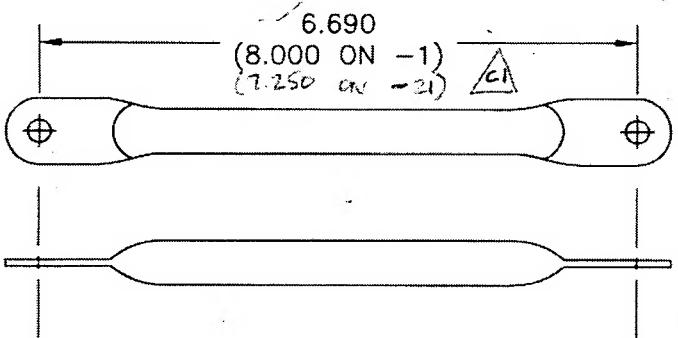
DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

REV. C

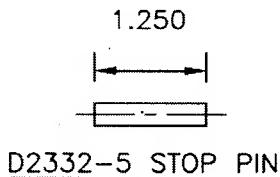
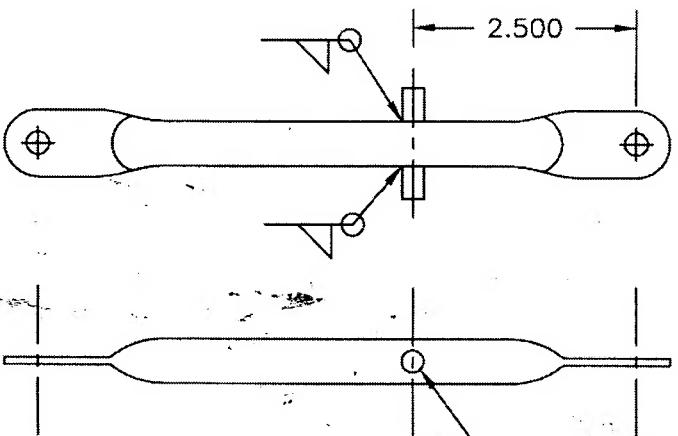
DESIGN	DRAWN BY	DART AEROSPACE LTD
		HAWKESBURY, ONTARIO, CANADA
DATE	APPROVED	DRAWING NO.
03.07.03		D2332
TITLE		SHEET 2 OF 2
C		LID PROP ASSEMBLY
C1		SCALE 1:2



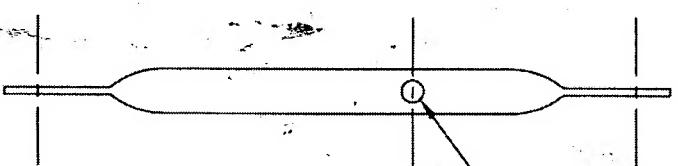
D2332-7 LOCKING COLLAR



D2332-11 PROP
(D2332-1 SIMILAR)



D2332-5 STOP PIN



DRILL 1/4 HOLE FOR D2332-5

D2332-13

M/F: D2332-11 & D2332-5

(D2332-3 SIMILAR = M/F D2332-1 & D2332-5)
(D2332-23 SIMILAR = M/F D2332-21 & D2332-5)



NOTES:

1. MATERIAL: 0.5 OD x 0.035 WALL SS TUBE (D2332-1/-11) M304TR0.500W.035
0.25 OD SS ROD 1.25 LONG (D2332-5) M303R0.250
1.0 OD x 0.049 WALL SS TUBE (D2332-7) M304TR1.000W.049
2. TUBE ENDS ARE CENTER-CENTER FOR D2332-1/-3 & D2332-11/-13

